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D3642-1

Job Sheet 196003



Part No: D3642-1

Job Qty: 8 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/25/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *sta*

Description:

Note: DWG REV B IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		6/25/19	0.17	0.72	Waterjet - Flow		<i>ac 19/08/02</i>
110	QC 2	8 pcs		6/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>ac 19/08/02</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	8 pcs	6/25/19	0.00 0.00	QC 21 - SA - 21	989
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.050	2024-T3 .050 Sheet	1.3312 sf (.1664 ea)	100-Waterjet - Flow - 1	S167934	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.050	1	83	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 196003
Description: Doubler		Part Number: D3642-1
Inspection Dwg: D3642	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	Ø.124	1		V-D-2	
Ø0.098	+0.004/-0.001	Ø.099	1		Type	
0.35	+/-0.030	.35	1			
1.25	+/-0.030	1.25	1			
1.700	+/-0.010	1.699	1			
2.15	+/-0.030	2.15	1			
3.05	+/-0.030	3.05	1			
3.95	+/-0.030	3.95	1			
4.078	+/-0.010	4.079	1			
4.85	+/-0.030	4.85	1			
5.20	+/-0.030	5.20	1			
0.343	+/-0.010	.345	1			
0.40	+/-0.030	.40	1			
1.30	+/-0.030	1.30	1			
3.35	+/-0.030	3.35	1			
3.47	+/-0.030	3.47	1			
3.79	+/-0.030	3.79	1			
3.959	+/-0.010	3.960	1			
4.08	+/-0.030	4.08	1			
4.60	+/-0.030	4.60	1			
1.537	+/-0.010	1.535	1			
3.28	+/-0.030	3.28	1			
3.80	+/-0.030	3.80	1			
3.915	+/-0.010	3.916	1			
0.450	+/-0.010	.452	1			
4.066	+/-0.010	4.065	1			
4.20	+/-0.030	4.20	1			

Measured by: [Signature]	Audited by:	Prototype Approval:	N/A
Date: 19/08/02	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:					



Container No: S202539



Part: D3642-1

Job No: 196003

Serial No/Batch: S202539

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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